

Work Order ID 160909

Friday, May 05, 2017 9:44:42 AM

160909

Page 1

Item ID: PB67-43001-63

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Assembly

Start Date: 5/16/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/23/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

Date:

MAY 05 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-63	Rev C

100

0.00

100

Large Fab

Large Fab

Memo

3.50

Large Fab

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg
- 9- assemble by drilling thru both -157 and -133 as per dwg
- 10- install spring slotted pin as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

DAS
24
9-89

MAY 26 2017

DAS
9
9-89

(2) 17-05-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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N900040100

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Stop *NS2*

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.14

Quality Control

DAS
9
9.99

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

1.49

mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

QC3- Inspect Part Finish

0.00

140

OC

Memo

0.07

Quality Control

2 ϕ 17-05-26 DAS 34 9-89

2

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Page 3

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: WAO03	0.00							
150									
Packaging	Memo WAO03 WAO03	0.07							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.70							
Quality Control									

MAY 29 2017

17/5/31

DAS
21
9-89

MAY 30 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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35 20				35 20				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Picklist Print

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Work Order ID: 160909

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Parent Item: PB67-43001-63

PR67-43001-63

Parent Item Name: Handle Assembly

Start Date: 5/16/2017

Required Date: 5/23/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-129 *PR67-43001-129*		Manufactured	No			100	Each	0.0000	1	7		MAY 26 2017	DAS 24 9-89
Tube Handle													
PB67-43001-127 *PR67-43001-127*		Manufactured	No			100	Each	2.0000	1	7		MAY 26 2017	DAS 24 9-89
Handle Arm													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				2					
				139141				2					
PB67-43001-157 *PR67-43001-157*		Manufactured	No			100	Each	7.0000	1	7		MAY 26 2017	DAS 24 9-89
Tube													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				Mezz2				7					
				153593				7					
PB67-43001-131 *PR67-43001-131*		Manufactured	No			100	Each	11.0000	2	14		MAY 26 2017	DAS 24 9-89
Tube End Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				11					
				142653				11					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID: 160909

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Parent Item: PB67-43001-63

PR67-43001-63

Parent Item Name: Handle Assembly

Start Date: 5/16/2017

Required Date: 5/23/2017

Start Qty: 7.00

Required Qty: 7.00

PB67-43001-133

Manufactured No

100

Each

1.0000

1

7

MAY 26 2017

DAS
24
9-89

PR67-43001-133

Clevis

**

Location

Loc Qty

Loc Code

Mezz2

1

153595

1

240-107

Purchased No

100

Each

90.0000

1

7

MAY 26 2017

DAS
24
9-89

240-107

SPRING SLOTTED PIN

**

Location

Loc Qty

Loc Code

ST579

90

m132006

1

m134651

89

CR3213-4-2

Purchased No

100

Each

178.0000

1

7

MAY 26 2017

DAS
24
9-89

CR3213-4-2

Cherry Rivet

**

Location

Loc Qty

Loc Code

CCK003

100

m137412

100

ST320

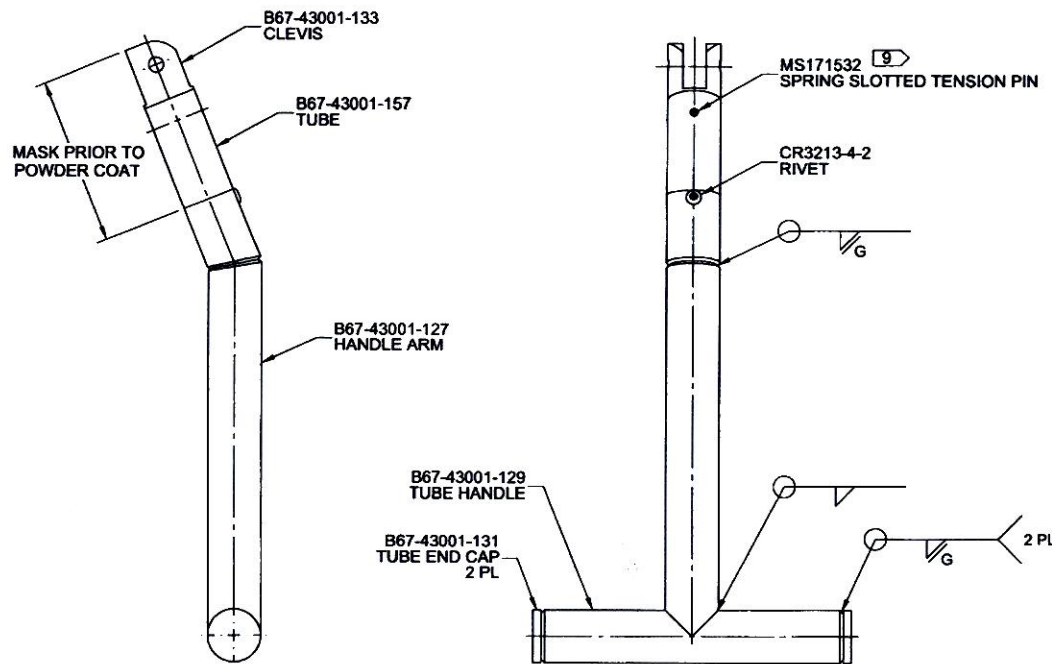
78

m136986

78

~~M136851~~ → 2
M137412 → 2

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I



B67-43001-63 SHORT T-HANDLE ASSEMBLY

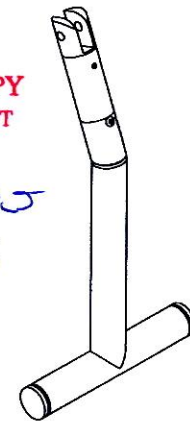
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs
- 8) WELDING: PER DART QSI 004
- 9) ALIGN B67-43001-133 AS SHOWN. ENLARGE PILOT HOLE LOCATED ON HANDLE AND DRILL THRU B67-43001-157-133. DRIVE MS171532 IN TO HOLE.

ITEM	QTY -63	P/N	DESCRIPTION
1	X	B67-43001-63	SHORT T-HANDLE ASSEMBLY
3	1	B67-43001-129	TUBE HANDLE
4	1	B67-43001-127	HANDLE ARM
5	1	B67-43001-157	TUBE
6	2	B67-43001-131	TUBE END CAP
7	1	B67-43001-133	CLEVIS
9	1	MS171532	SPRING SLOTTED TENSION PIN (OR 240107)
10	1	CR3213-4-2	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160909145
170501



RELEASED
R 2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	RS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-63	SHEET 1 OF 1	
APPROVED	MA	TITLE	SCALE	
DE APPR.	N/A	SHORT T-HANDLE ASSEMBLY	NTS	
DATE	09.06.10	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		